

Date: Tuesday, 30/10/2007 11:05:27 AM
User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	AFT CROSSTUBE		
Job Number	35421			Part Number	D2890		
Estimate Number	10377			Drawing Number	D2890 REV B		
P.O. Number	:			Project Number	N/A		
This Issue	30/10/2007	S.O. No.	:	Drawing Revision	B		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	PURCHASED PARTS	Due Date	15/11/2007	Qty:	1
Previous Run	35261			Um:	Each		
Written By	:						
Checked & Approved By	:						
Comment	Est. D 05/03/21 Removed Bending procedures KJ/JLM						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6008180	Crosstube extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part # Description Batch 1 D6008-180 Crosstube extrusion <i>B23969</i> <i>EL 7-10-30</i>		
2.0	BENDING	BENDING MACHINE
Comment: BENDING MACHINE <i>1-Bend D2890 as per Dwg D2890 and Folio FT002</i> <i>EL 7-10-30</i>		
3.0	QC6	DIMENSIONAL CHECK
		 <i>JUL 10 2008</i>
Comment: DIMENSIONAL CHECK		
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 <i>1-Deburr and Polish</i> <i>N/A</i>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		 <i>N/A</i>
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005.4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT CROSSTUBE

Job Number: 35421

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



N/A



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W10 35427 (-103)*

07.10.30

8.0 QC21 FINAL INSPECTION/W/O RELEASE



07.10.31

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



07.10.31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

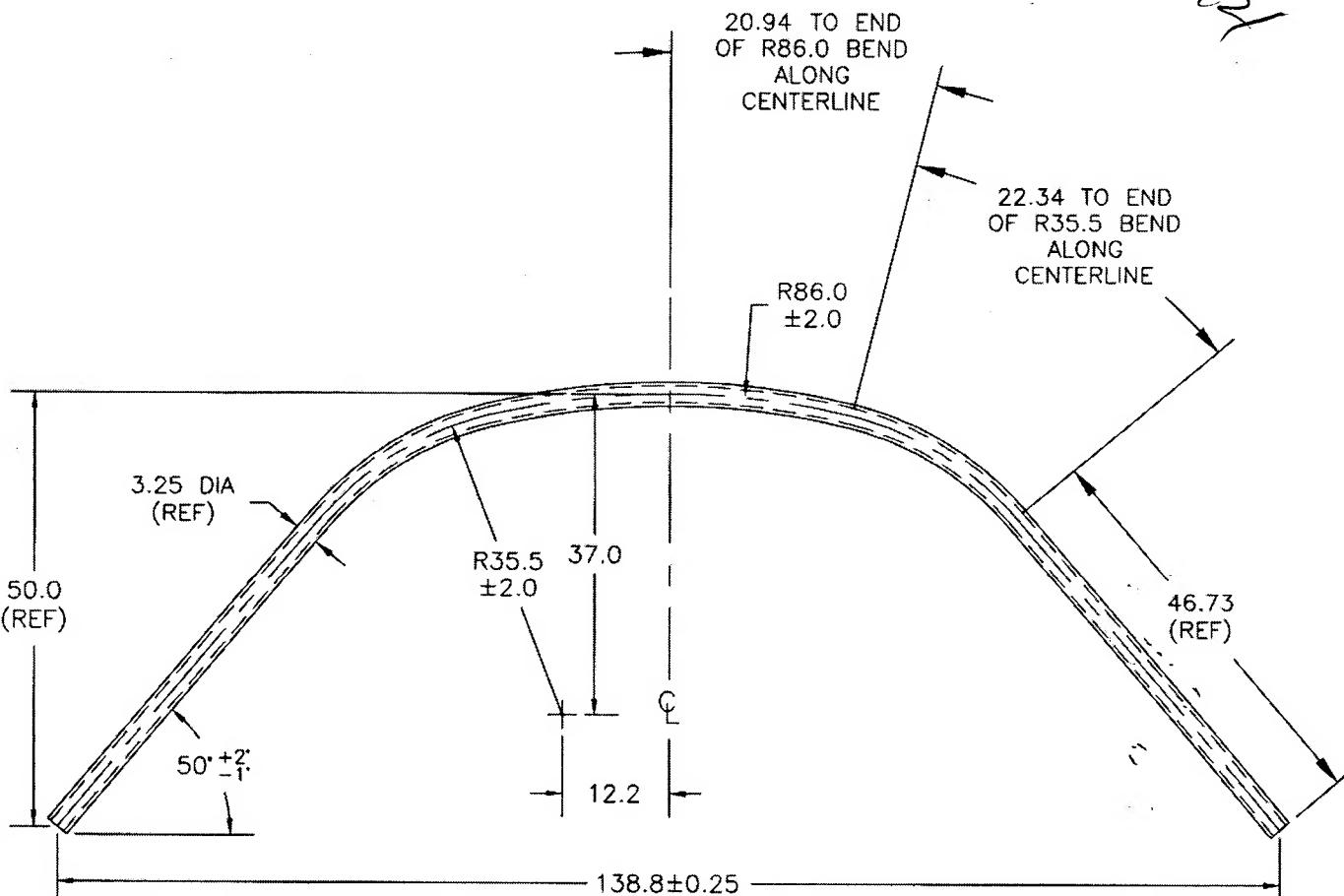
NOTE: Date & initial all entries

W0950X

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD		
		HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D2890	SHEET 1 OF 1	
DATE				
A	02.10.18	TITLE		
B	02.10.18	AFT CROSSTUBE	1:20	SCALE
		NEW ISSUE		
		ADD TANGENT LENGTHS; CHANGE NOTES		



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

35421

Description: Crosstube Aft

Part Number:

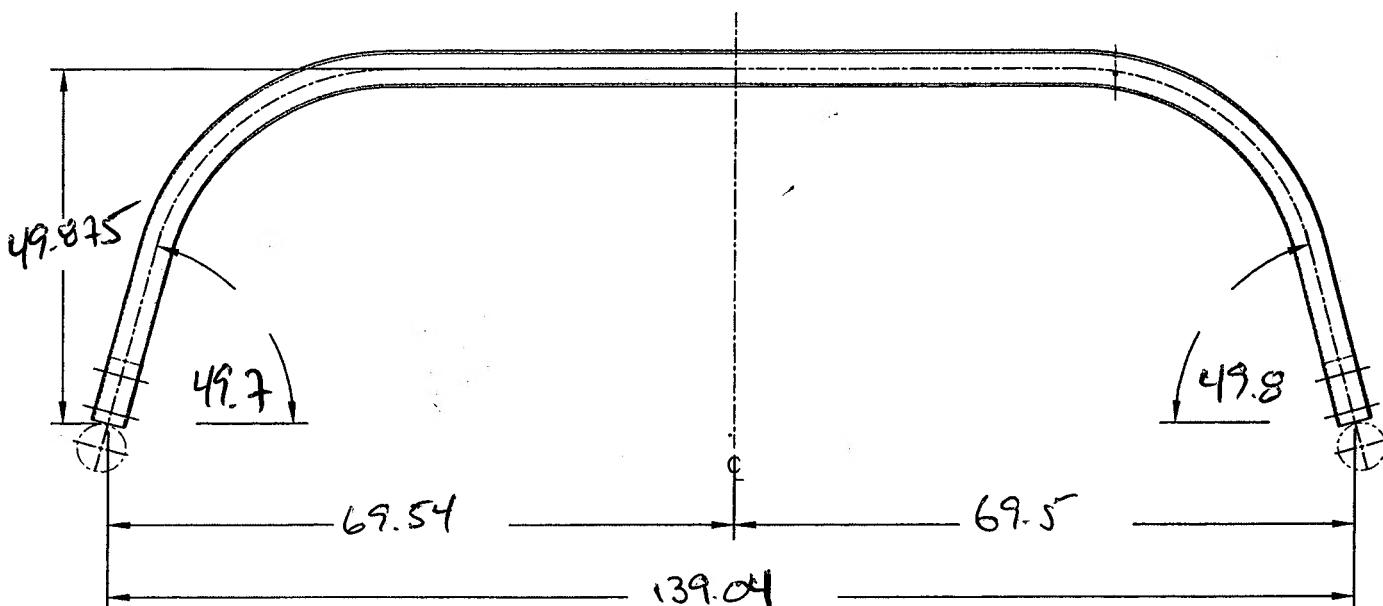
D2890

Inspection Dwg: D2890

Rev: B

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Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



Comments	
Tube is perfect for D205-596-103 B35427	

QC15 Inspection	
Date	02-10-30

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>